

510

DART AEROSPACE LTD		Work Order:	22079
Description: Bracket		Part Number:	D3207-1
Dwg: D3207 Rev. A page 1			D3207-2
		Qty:	4 30 40
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC RF 04.06.08	Issue Traveler Note: To be made in multiples of 10- Dwg not required	HA	14.12.08	4
2	MV	(1) Flat pattern makes either D3207-1 or D3207-2 Cut blank: 6.5100" x 2.880" (+0.020/-0.000) grain along 2.880" Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3207-1/-2 Batch: M110203	SD EP	04/12/10	
3	MV	Machine as per Folio FA341 and Dwg D3207 Stack of 10	EP	05/01/10	40
4	QC2	Inspect parts as they come off the CNC machine	EP	05/01/10	40
5	QC8	Second check	EP	05/01/10	40
6	GA	Deburr	2nd	05/01/10	40
7	GB	Form 1/2 of stack for D3207-1 as per Dwg D3207 Identify as D3207-1	2	05.01.24	40
8	GB	Form second 1/2 of stack for D3207-2 as per Dwg D3207 Identify as D3207-2	2	05.01.24	40
9	QC5	Inspect work to Step 8	2	05.01.24	40
10	FP	Chemical Conversion Coat as per QSI 005 4.1	MA	05/01/25	4
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	MA	05 01 25	4
12	QC3	Inspect Powder Coat	MA	05 01 26	4
13	ST	Identify and Stock D3207-1 Qty: 4 D3207-2 Qty: 40	CL	05/01/27	44
14	AC	Parts to Stock and Prorate cost to parts per Step 13 Cost / part 7.63 7.62	CL	05/01/27	44
15	DC	Close W/O 7.63 7.62 Inspect Level 21	SAC	05.01.27	44
			HA	05.02.12	44

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	

RELEASED
11/04/05-18

Dart Aerosp.

Job Costing Report

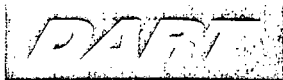
Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No	:	0022079	Department Code:	
Project Name	:	D3207-2	Burden Flags	: NNNNNNNN
Project For	:	WK503	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3207-2	Invoice Number	:
Description	:	Bracket	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	4	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	12-06-04		
Est Finish Date	:	01-15-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

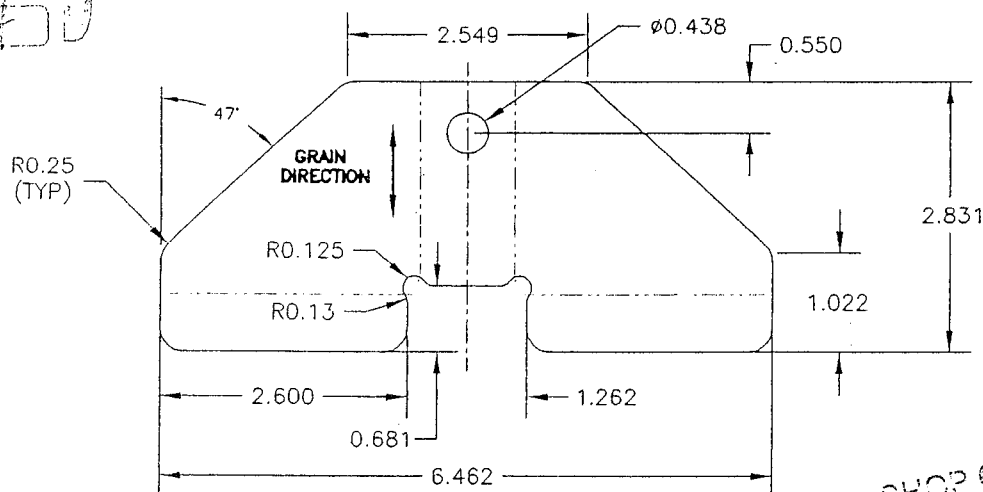
	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

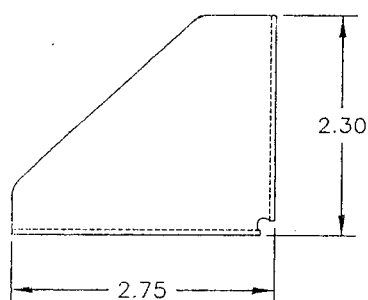
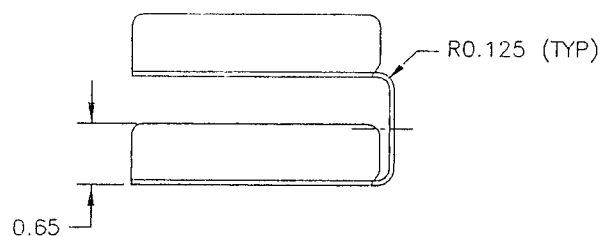


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3207	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

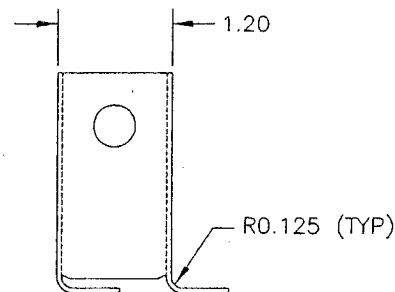
RELEASED
04.04.05



D3207-1/-2 FLAT PATTERN



**D3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITE**



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22079

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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Work Order: 22079

Definition: BRACKET

Part Number:	D3207-1
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DISPATCHED BY: D3207 Rev: A

D3207-2

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FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured By:

3

Audited by:

an

Prototype Approval:

5316:

05/01/20

Date:

05/01/20

Date:

Rev

Date _____

Change

New Issue

Revised by

KJ/JLM

Approved